

129409

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 2/6/2015 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 2/6/2015 **Req'd Qty:** 10.00

10

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: MLT

Date: 15-02-06 Tooling:

Date:

Stop *NR2*

QC:

Date: _____ SPC (Y/N): _____

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3401	Rev B

100			0.00
100	BAND SAW		
Bandsaw			
	Memo		0.00
Jeaspa Bandsaw	Cut Blanks 4.20" Long		

DAS
37
9-89 15-02-23

110		0.00
110	DOOSAN LATHE	
Doosan	Memo	0.00
Doosan Lathe	Turn as per Folio FA532 & Dwg D3401	
	Folio Rev: <u>AA</u>	Dwg Rev: <u>1</u>
	Debur	

DAS
25
9-89 15-2-25

120	QC2- Inspect parts off machine FAI/FAIB	0.00
120		
QC	Memo	0.00
Quality Control		

DAS
25
9-89 15-2-25-

129409

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 2/6/2015 **Start Qty:** 10.00 ***10***

Cust Item ID:

Required Date: 2/6/2015 **Req'd Qty:** 10.00 ***10***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:**

Date: _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

Work Order ID 129409

Friday, February 06, 2015 11:15:21 AM

129409

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Item ID: D3401-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Tow Cap Assembly

Start Date: 2/6/2015 Start Qty: 10.00

10

Cust Item ID:

Required Date: 2/6/2015 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150	Small Fab					10	FF		MAR 10 2015
Small Fab	Memo	0.00							
Small Fab	Drill and c'sink using DT8782 as per Dwg D3401								
160		0.00							
160	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
170		0.00							
170	Chemical Conversion Coat per QS1005 4.1					10	Ø		Jm15-3-11
HandFinish	Memo	0.00							
Hand Finishing									

DAS

38

9-88

MAR 11 2015

Work Order ID 129409

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Friday, February 06, 2015 11:15:21 AM

Item ID: D3401-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Tow Cap Assembly

Start Date: 2/6/2015 Start Qty: 10.00

10

Cust Item ID:

Required Date: 2/6/2015 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

180

M 124808

10 x 4 15-3-18

DAS 34 9-89

Powdercoat

Memo

0.00

Powder Coating

START TIME: 2:30
OVEN TEMPERATURE: 320°
FINISH TIME: 3:00

190

QC3- Inspect Part Finish

0.00

190

10 x 4 all 15/03/23

DAS 15 9-89

QC

Memo

0.00

Quality Control

195

Assemble as per dwg

0.00

195

10 x 4 all 15/03/23

HandFinish

Memo

0.00

Hand Finishing

Work Order ID 129409

Friday, February 06, 2015 11:15:21 AM

129409

Page 5

Item ID: D3401-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tow Cap Assembly

Start Date: 2/6/2015 Start Qty: 10.00

10

Cust Item ID:

Required Date: 2/6/2015 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

10 ϕ 15-3-23 **DAS 34 9.88**

210

Identify as per dwg & Stock Location: **F12061**

0.00

210

Packaging

Memo

0.00

Packaging

x 10 ϕ **ll** 15/6 2/23

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

MLJ 15-3-23

CMF

15-3-23

Picklist Print

Friday, February 06, 2015 11:15:27 AM

Page 1

Work Order ID: 129409

Parent Item: D3401-041

Parent Item Name: Tow Cap Assembly

129409

D3401-041

Start Date: 2/6/2015

Required Date: 2/6/2015

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A05.09.01New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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NAS1330C3KB116 Purchased

NAS1330C3KB116

Rivnut

Location	Loc Qty	Loc Code
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FP001	34	
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103337	34	
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ST267	16	
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M129913	16	
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M6061T6R3.500 Purchased

M6061T6R3 500

6061 RD bar 3.50

Location	Loc Qty	Loc Code
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MAT013	7.39	
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m130089	7.39	
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**

**

all 2/6/2015

1125322
11131677

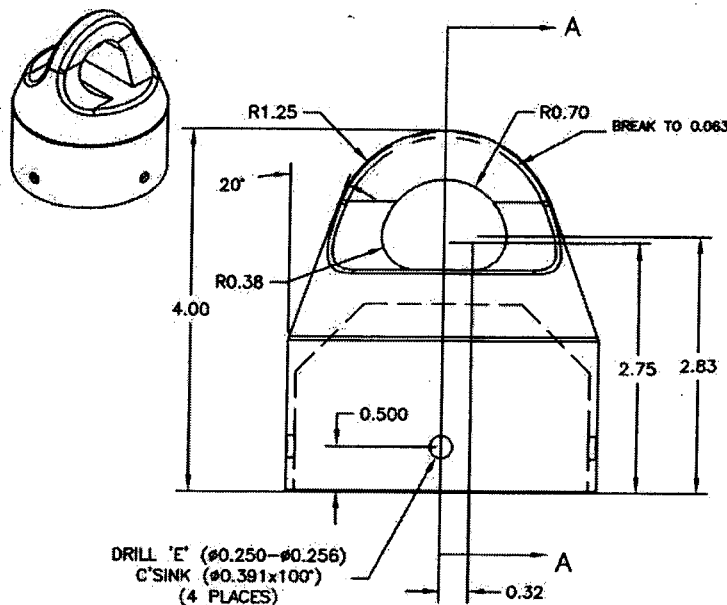
18

132

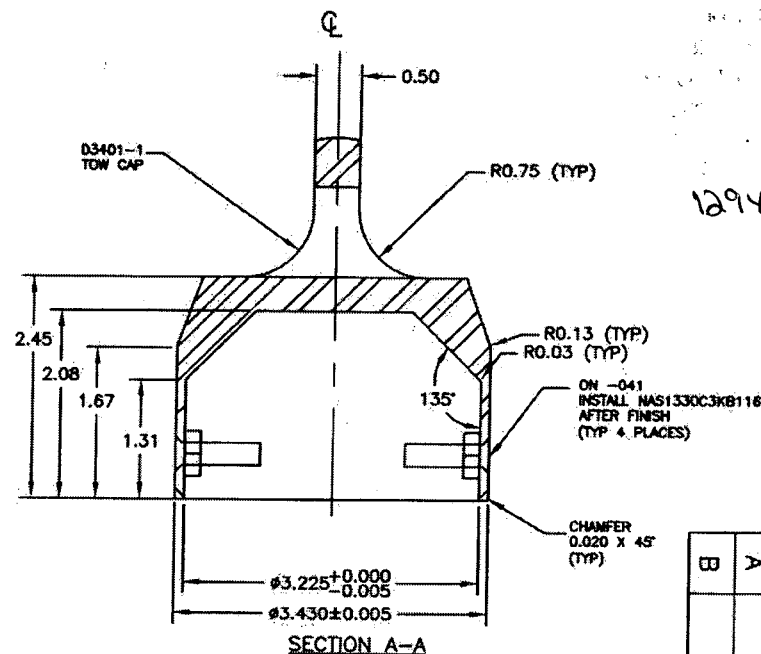
DAS
37
9-89

15.02.23

3.55 ft.



D3401-1 TOW CAP



D3401-1/-041 TOW CAP

D3401-1 TOW CAP

- 1) MATERIAL: MAKE FROM ALUMINUM 6061-T6 Ø3.500 ROUND BAR PER QQ-A-225/8 OR AMS-QQ-A-200/8 (REF. DART SPEC M6061T6R3.5000)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3401-041 TOW CAP

- 1) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

D3401-041 TOW CAP PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3401-1	TOW CAP
4	NAS1330C3KB116	INSERT

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.06.09	TITLE	D3401	REV: B
			TOW CAP	SHEET 1 OF 1
			NEW ISSUE	SCALE
			CHAMFER INSIDE, REMOVE RADIUS	1:2

DART

RELEASED
05.08.07